

Date: Thursday, 02/04/2009 2:25:43 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 46845		
Estimate Number	: 11048		
P.O. Number	:	Part Number	: D28443
This Issue	: 02/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2844 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 39543	Drawing Revision	: A
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 10/04/2009
Checked & Approved By	: <u>JUD 09-04-02</u>	Qty:	20 ² 10 Um: Each
Comment	: Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.8533 f(s)/Unit Total : 18.5325 f(s)

304 RD Tube .500 x .035W

M304TRO500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 19.82" long (Hole ctr. to hole ctr.) using Jig

DT 8012

Batch

M111704

M-L 04/06/21

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



(20X)

Comment: BAND SAW

Form per Dwg D2844 using brake and bending Jig DT 8238-B

Deburr

M-L 04/05/21

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



count

Comment: INSPECT WORK TO CURRENT STEP

S 04/05/21

(x20)

4.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



M111472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

7:30 AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

8:00 AM

M 09-05-26

(220)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 46845

Part Number: D28443

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/26

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure parts are still as per dwg D2844

Sort 09/05/26

center x20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



200

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 265

9/5/27

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

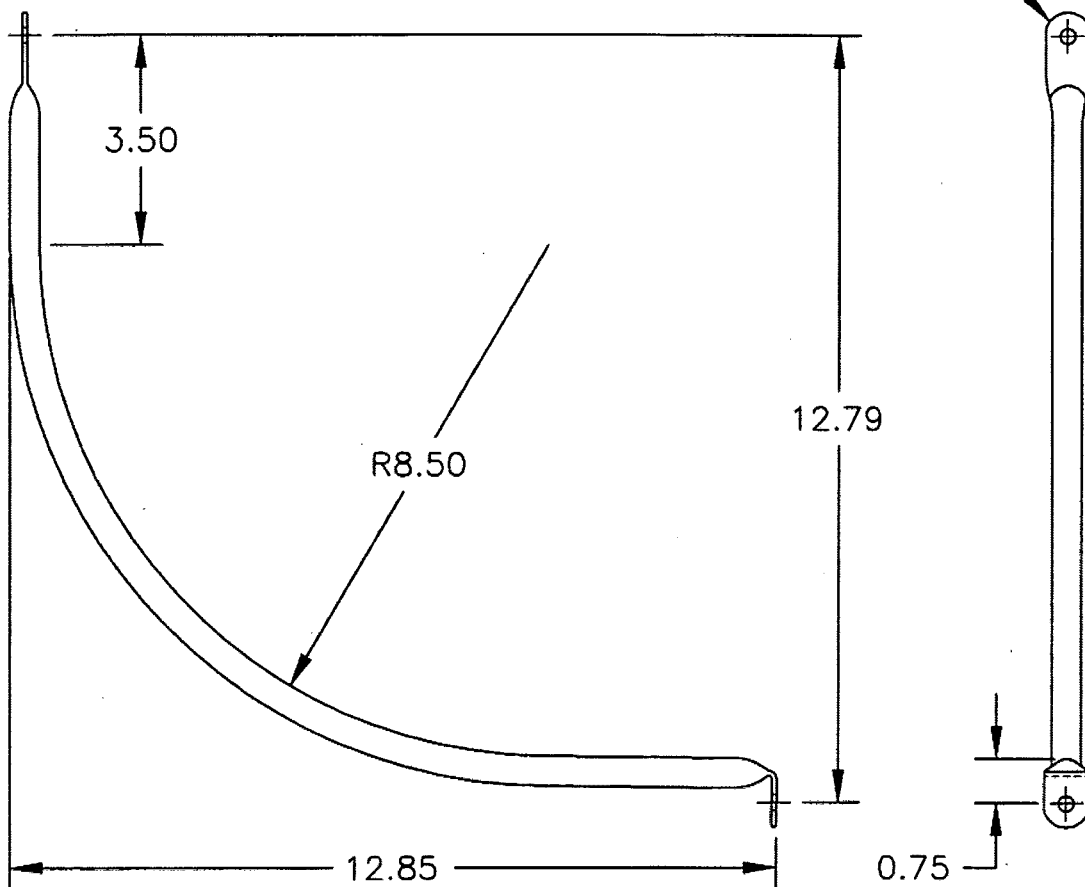
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

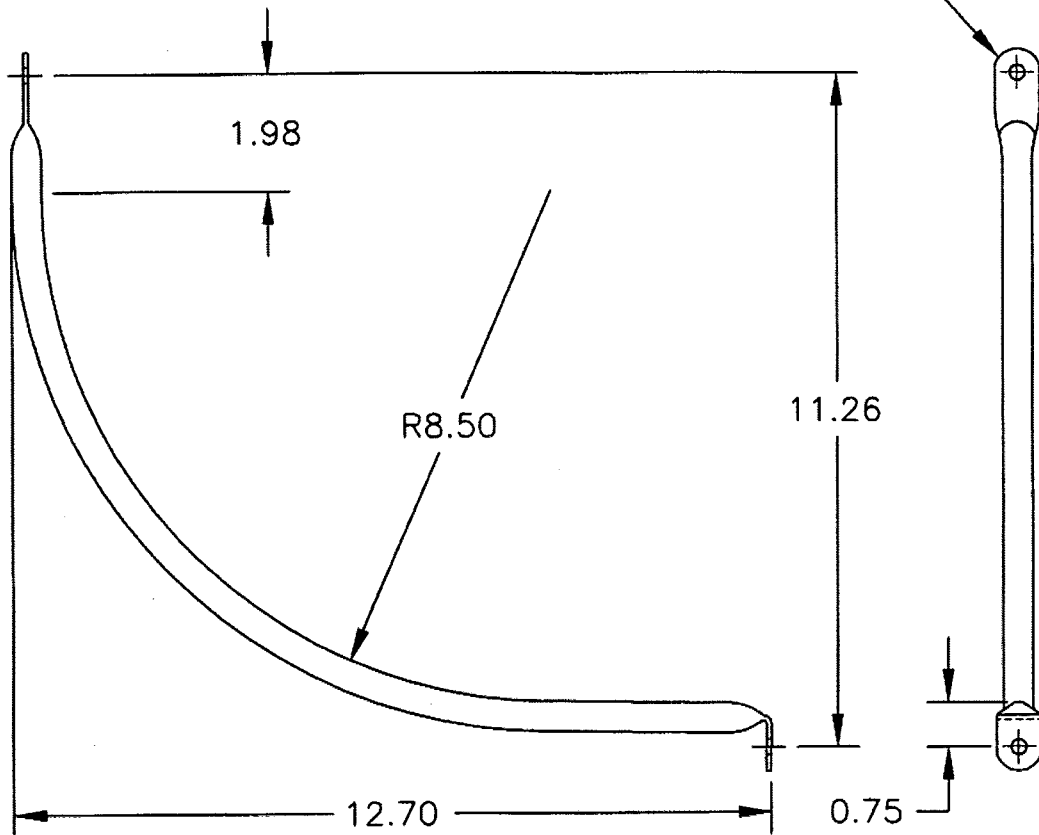
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WORK CENTER
NO. *46845*

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DH</i>	APPROVED <i>KE</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
18.11.11 *KG*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

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NO. *46845*